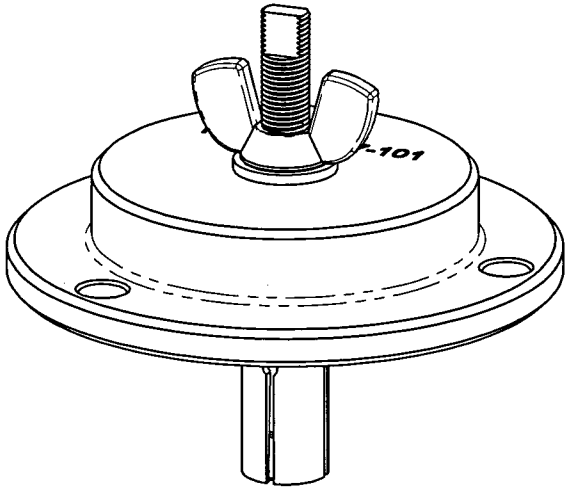
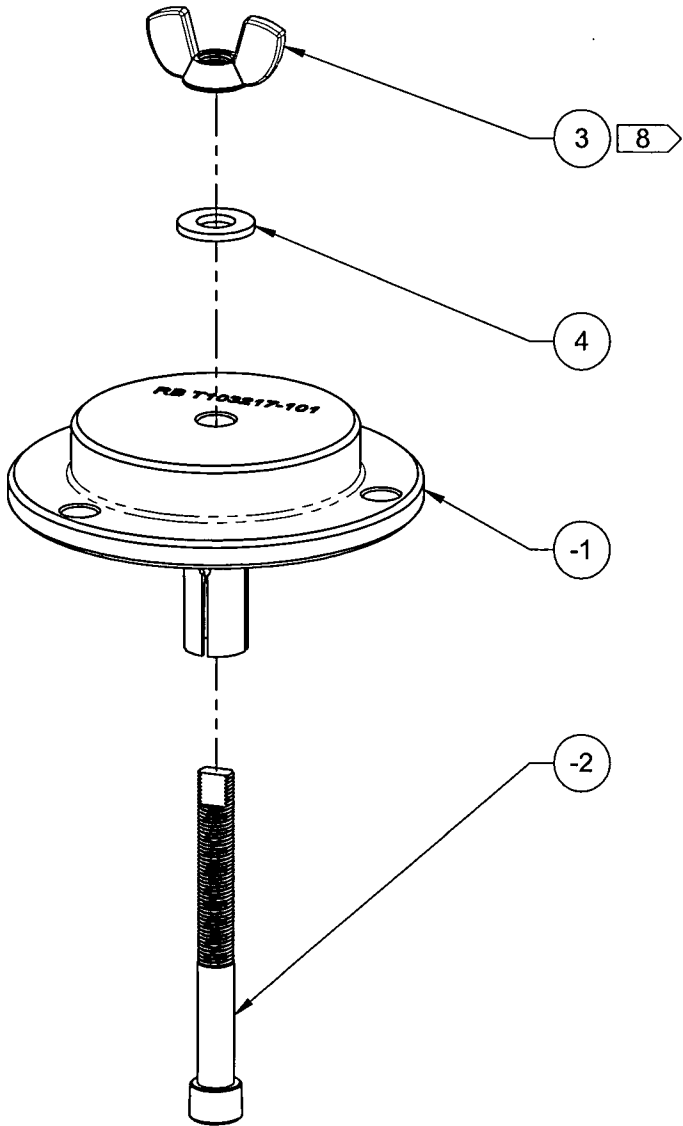


ITEM #	QTY	PART #	PART TITLE
-1	1	RB T103217-101-1	BODY
-2	1	RB T103217-101-2	ANVIL
3	1	McMaster#92001A342 OR EQUIV.	SS WING NUT 3/8"-24 X 3/4" THK.
4	1	McMaster#97416A127 OR EQUIV.	STEEL WASHER 0.406" ID. X 0.812" OD.



RB T103217-101 COLLET ASSEMBLY TOOL

9

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: N/A
 - 8) ASSEMBLE AS SHOWN, INSTALL ITEM 3 HAND TIGHT
 - 9) APPLY A SMALL AMOUNT OF NICKEL ANTISIEZE TO THE THREADS OF ITEM -2
 - 10) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

D	UPDATED DRAWING TEMPLATE. UPDATED DASH NUMBERS. -1 CH'D HOLE LOCATION DIMENSION WAS 1.600 IS 1.320. CH'D HOLE LOCATION DIMENSION WAS 1.320 IS 1.600. -2 CH'D MATERIAL WAS McMaster#91251A473 IS McMaster#92196A371. REMOVED BLACK OXIDE FINISH	18-772	KPT
C	UPDATED TO NEW DRAFTING STANDARDS. -1 CH'D MAT'L WAS 4140 Q&T IS 4140 Q&T/4142 Q&T.	N/A	DPD
B	REDRAWN IN SOLIDWORKS. -1 CH'D HOLE SPACEING WAS 3X EQUALLY SPACED ON B.C.Ø3.687 IS 1 AT 1.600 X .918, 1 AT 1.320 X 1.288, 1 AT 1.845 X .000. -3 CH'D B/O WAS MCMASTER-CARR #91251A474 IS MCMASTER-CARR #91251A473.	N/A	CFS
A	CH'D TITLEBLOCK & REVISION BLOCK, CH'D TOOL NUMBER FROM T103217-101 TO RB T103217-101, ADDED NOTE TO COMPLETELY GROOVE SLOTS PER R.W.	N/A	RJC
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	TOOL PART #	REV. D
MFG. APPR.	FK	RB T103217-101	SHEET 1 OF 3
APPROVED	M. Lee	TITLE	SCALE
DATE	05/09/2018	COLLET ASSEMBLY TOOL	NTS
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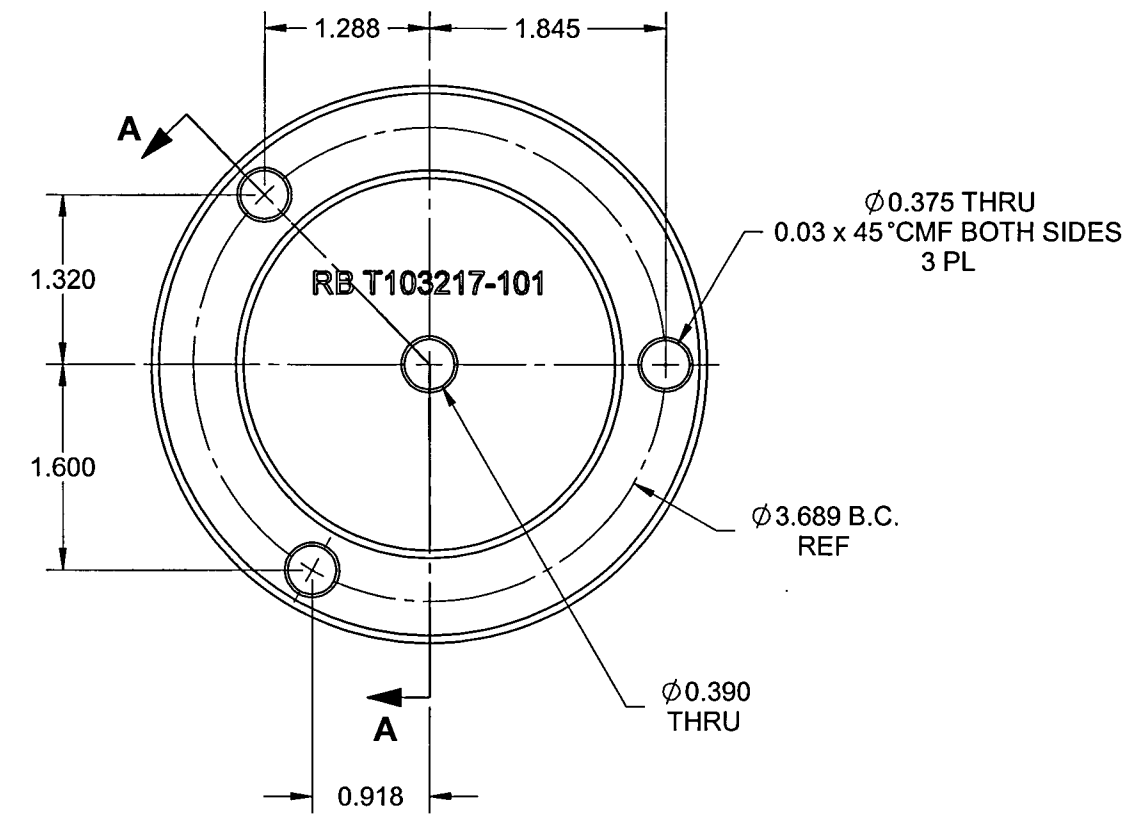
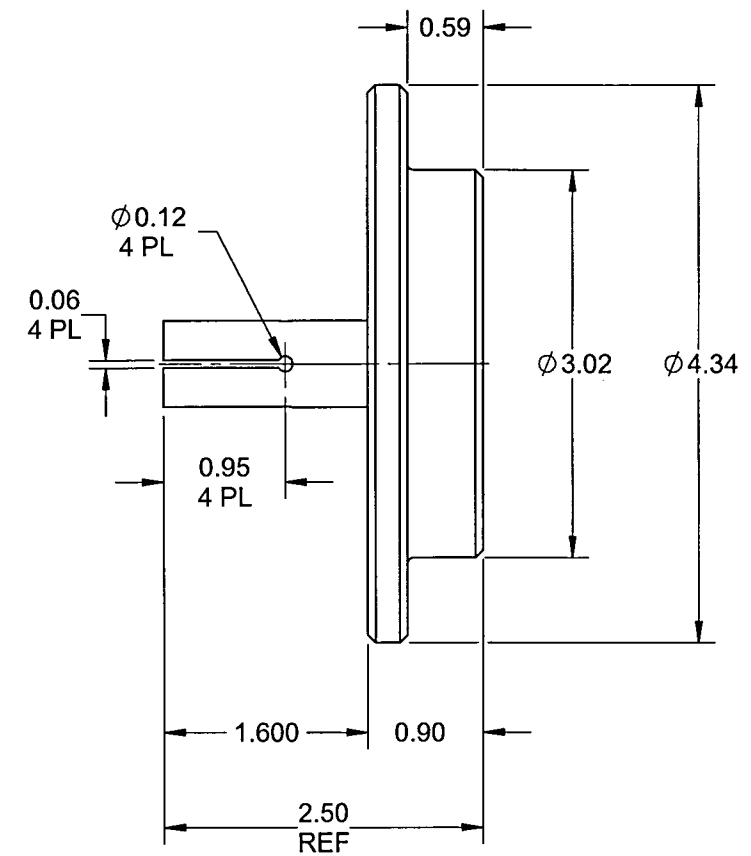
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D

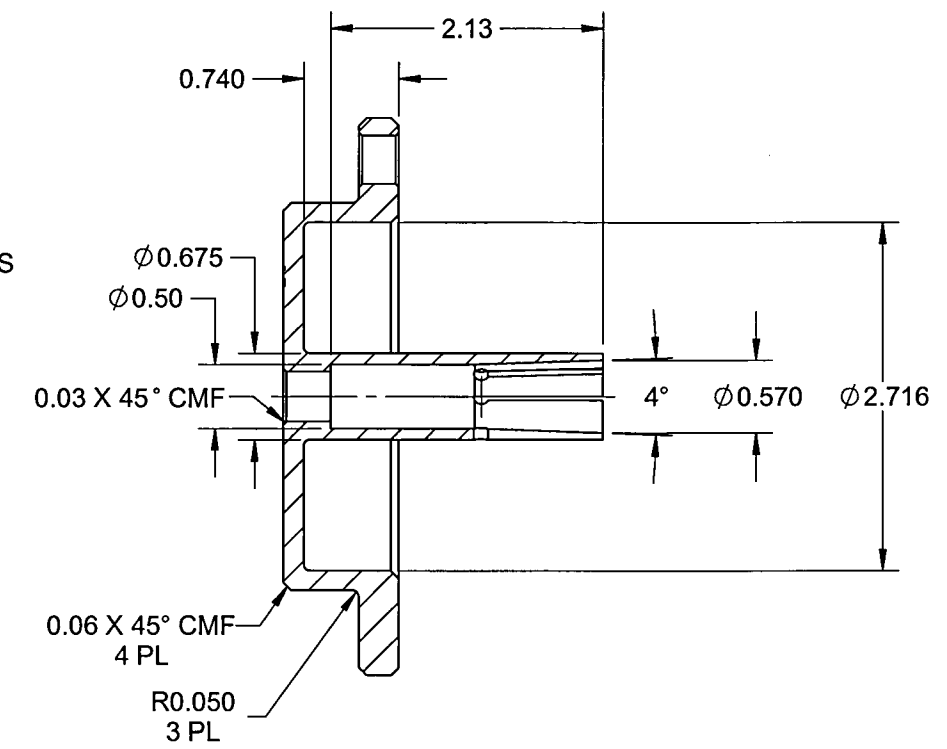
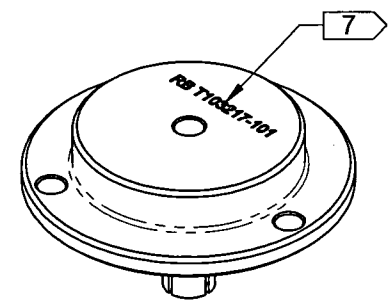
C

B

A



RB T103217-101-1 BODY



SECTION A-A

NOTES:
1) MATERIAL: 4140/4142 (28-32 RC)
2) HEAT TREAT: N/A
3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: MACHINE ENGRAVE PER CAD MODEL AS SHOWN OR DOT MARK T/N AS SHOWN

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	TOOL PART #	REV. D
MFG. APPR.	FK	RB T103217-101	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DATE 05/09/2018		COLLET ASSEMBLY TOOL	NTS
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8 7 6 5 4 3 2 1

D

C

B

A

D

C

B

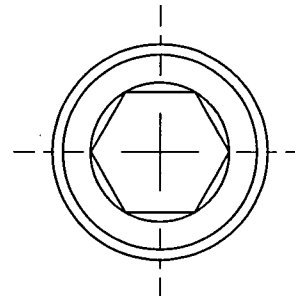
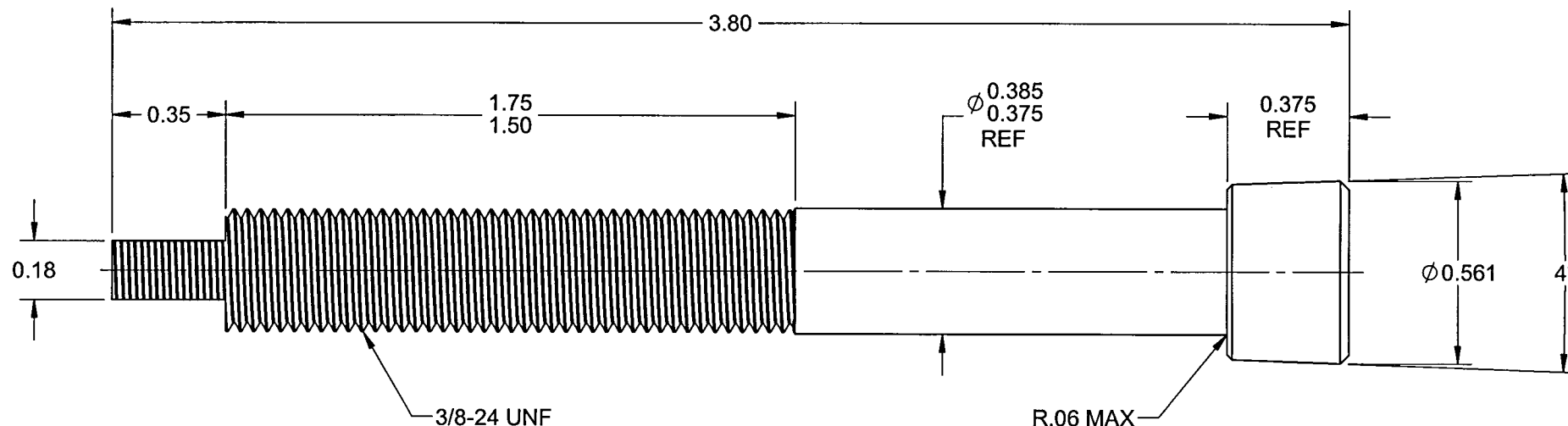
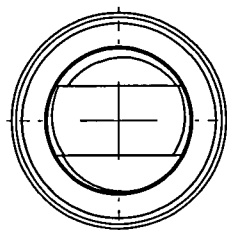
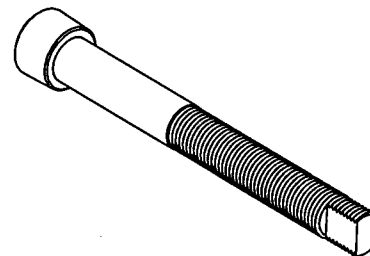
A

D

C

B

A



RB T103217-101-2 ANVIL

NOTES:
1) MATERIAL: McMaster#92196A371 OR EQUIV.
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005" TO 0.010"
7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	ML	TOOL PART #	REV. D
MFG. APPR.	FK	RB T103217-101	SHEET 3 OF 3
APPROVED	<i>ML</i>	TITLE	SCALE
DATE 05/09/2018		COLLET ASSEMBLY TOOL	NTS
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